

Α DESCRIPTION MATERIAL MAT. LOCATION NOTES: (UNLESS OTHERWISE SPECIFIED) I. THIS IS A CRYOGENIC VACUUM COMPONENT. 2. WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL. 3. CLEANING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL. Ø.472 TUBE PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS: [ | 2 ] PER VENDOR SPCIFICATION WITH LBNL APPROVAL. 5. DIMENSIONS AND TOLERANCING PER ANSI YI4.5M-1982. UNITS ARE IN INCHES UNLESS OTHERWISE SPECIFIED. USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS, OR COOLANTS ARE STRICTLY PROHIBITED. 2.13 USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER [54] IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES 8. VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBECT TO 3 LBNL APPROVAL. 9. ELBOWS MAY BE USED ON THE TUBE BENDS AS NEEDED. 3.00 II. VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE [76.2] FABRICATION OR ASSEMBLY: SUBECT TO LBNL APPROVAL. 12. REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY AND CLEAN ENDS. 13. TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS WITHIN + / - .010. [54] 14. PERFORMANCES: PERFORMANCES PER LBNL ACCEPTANCE CRITERIA SEE SPECIFICATION NUMBER LBNL No. M8056 AND BY VENDOR AND LBNL APPROVED 1.50 SPECIFICATION. [38.1] a) OPERATING TEMPERATURE 4.2°K. -∅.500 TUBE b) THERMAL SHOCK WELDS TO LN TEMEPRATURE 2 TIMES ONE HOUR [12.7] INTERVAL TEST PRESSURE 375 PSIG. d) VACUUM CHECK WITH HELIUM LEAK MASS SPECTROMETER DETECTOR. THERMAL CONTRACTION THE LEAK RATE AT ANY LOCATION SHALL NOT EXCEED I X 10-9 STD CC/SEC. [25.4] TRAVEL FROM SHOWN POSITION I5. EST. WT.: WEIGHT: UNLESS OTHERWISE SPECIFIED | SHOP ORDERS ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY X.X ± 0.1 FRAC. ± 1/64  $X.XX \pm 0.03$  Angles  $\pm 1.00^{\circ}$ UNIVERSITY OF CALIFORNIA - BERKELEY X.XXX ± 0.010 FINISH 125 (prin) SURFACE TREATMT LHC IR FEEDBOX IDENT TAG METHOD TAG PROJECT N/A PROJECT DO NOT SCALE PRINT CRYOGENICS THREADS ARE CLASS 2 BRAIDED FLEX HOSE, 1/2" ID X 3" LIVE LENGTH, 12mm X 1/2" ELBOW WELD ENDS CHAMFER ENDS OF ALL SCREW TREADS 30° CHAMFER ENDS OF ALL SCREW INLANDS 30 NAME
CUT ROUND, I.5 THREAD RELIEF ON MACHINED THREADS DWG A. HARRIS DWG. TYPE SHOWN ON SCALE: 3/4 DO NOT SCALE PRINTS PART VARIOUS SHEET 1 OF 1 DATE | 3-Jul-02 BREAK EDGES .016 MAX. ON MACHINED WORK PATENT CLEAR: DESIGN ACCT. NO. CATEGORY CODE DW K J. ZBASNIK DATE REMOVE BURRS. WELD SPLATTER & LOOSE SCALE 2516523 Z5LCE2 | LH2003 | CHANGES R J. ZBASNIK | REV | DWG | CHK | ZONE | DATE IN ACCORDANCE WITH ASME YI4.5M & B46.I DATE D С В